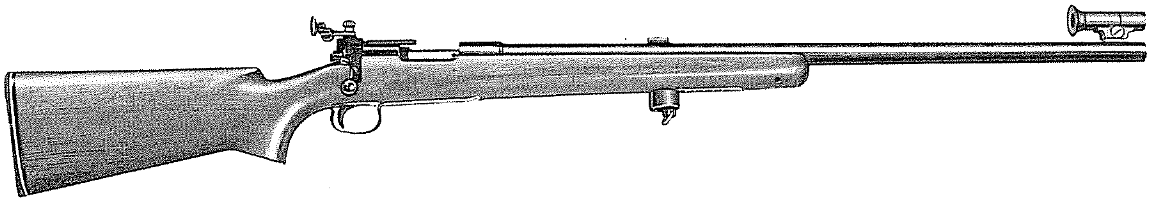
FIELD SERVICE MANUAL

The Remington "Rangemaster" Model 40X is a bolt action 22 caliber match rifle. This rifle is of single shot solid frame design chambered for long rifle cartridge only. The gun action is hand operated and similar in function with most rifles of the bolt action type.

In addition to the detailed assembly instructions, design information will also be included to better acquaint the reader with the purpose of each part.

A sectional view is included as a final page to assist in the proper identity of components.



FIELD SERVICE MANUAL

The paragraph headings for the ASSEMBLY section are arranged in the most practical working order. This order, if followed as numerically listed, will remove and replace the parts in their proper order. Components not listed in this index will be found in the detailed instructions.

1. BOLT ASSEMBLY Page 2 - 3
2. BOLT ASSEMBLY - COMPONENTS 4 - 8
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8. STOCK ASSEMBLY - COMPONENTS 15 - 16
9. BEDDING ESCUTCHEON ASSEMBLY - COMPONENTS 16
10. SIGHTS 17

A design relationship exists between the Model 40X and the Models 721-722. The safety action, the cocking of the firing pin, and the engagement of components (to some extent) which affect the trigger pull, operate in a similar manner. A number of components, identified with these functions, carry the same part number in the Parts Price List.

CAUTION: Make certain no cartridge is in barrel before handling.

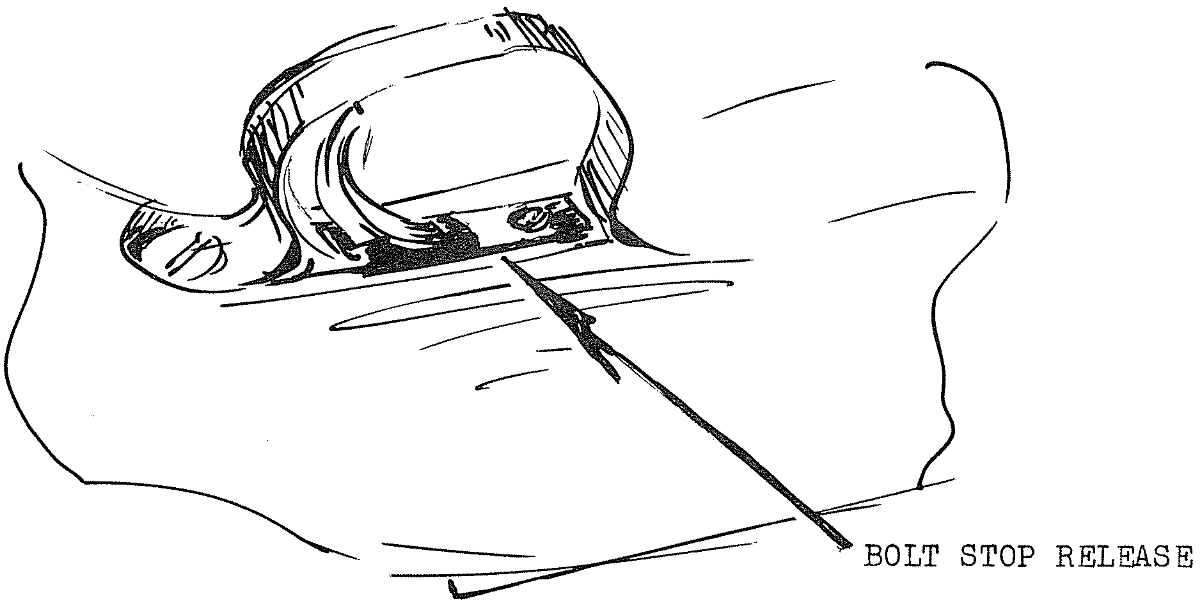
1. BOLT ASSEMBLY:

This assembly is designed to close and lock the action securely to the barrel breech against the chambered round. The loading, firing and extracting mechanism is carried within this part.

Push safety forward to "FIRE" position (Bolt handle will not raise if safety is in rear or "ON SAFE" position.)

Raise bolt handle and pull bolt assembly rearward.

Press upward on bolt stop release located in front of trigger. See sketch below.

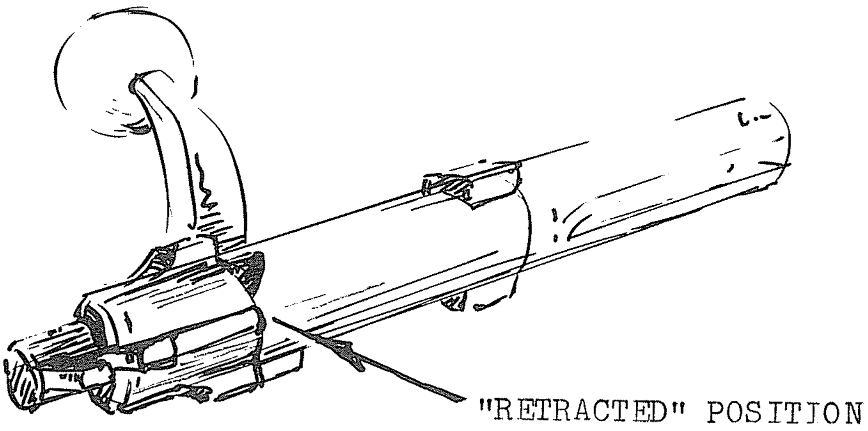


Continue pulling bolt assembly rearward and disassemble from receiver of rifle.

The bolt assembly is factory listed to include the bolt body assembly, firing pin assembly, bolt head, bolt pin (2), extractor, left; extractor, right; extractor plunger (2), extractor spring (2).

1. BOLT ASSEMBLY: (Continued)

NOTE: Normal removal of the bolt assembly from the rifle will retract or draw back the firing pin. The firing pin head, pinned to the rear of the firing pin will then hold the firing pin in a retracted position. The bolt assembly can not be replaced to rifle unless the firing pin is in this retracted position. See sketch below.



If firing pin has been released forward for some reason, with the bolt assembly removed from the rifle, it may be retracted in the following manner...

Hold flat under section of firing pin head tightly in a vice jaw, then...

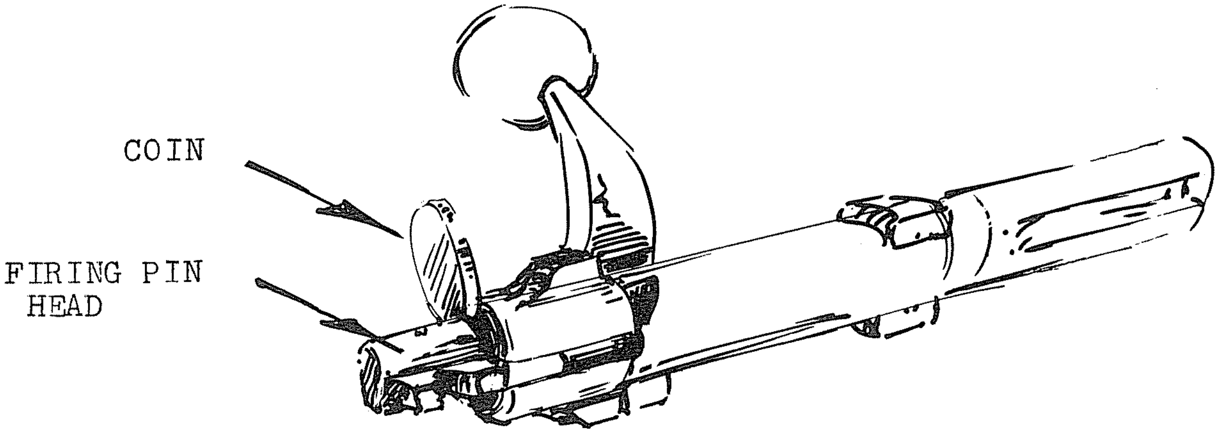
Simply raise bolt handle upward. This movement of the handle will cam the bolt body forward and permit the retraction of the firing pin to a notched position on the rear under rim of the body assembly.

IMPORTANT: Bolt assemblies are numbered on under surface to match the rifle number. Close headspace and firing pin indent measurement limits require precision assembly of bolt assembly components. Therefore, any replacement of the bolt assembly requires careful assembly to maintain proper headspace and firing pin requirements.

2. BOLT ASSEMBLY - COMPONENTS:
   (With bolt assembly removed from rifle)

Firing Pin Assembly - is designed as a spring powered striker to indent the cartridge primer and explode the round. To disassemble from bolt assembly...

Pull back or retract firing pin head from bolt plug until coin or similar flat tool can be wedged between firing pin head and bolt plug. See sketch below.



Hold firing pin head in this retracted position and unscrew bolt plug from bolt body assembly.

Pull out and disassemble firing pin assembly from bolt body assembly - bolt head. NOTE: Bolt head will revolve when firing pin is withdrawn.

NOTE: The firing pin assembly - is factory listed to include bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.

Reassemble in reverse order. Take care that firing pin aligns properly in hole in front of bolt head.

Firing Pin Assembly - Components
  (With assembly disassembled from bolt assembly)

Firing Pin Head - is designed to "retract" the firing pin and notched to hold "cocked" against the upthrust sear. To disassemble...

Pull back and hold firing pin head against compressed main spring.

2. BOLT ASSEMBLY - COMPONENTS: (Continued)
(With bolt assembly removed from rifle)

Firing Pin Head (Continued)

Drive out firing pin cross pin visible in side of retracted firing pin head.

Disassemble tightly fitted firing pin head from rear shank of firing pin.

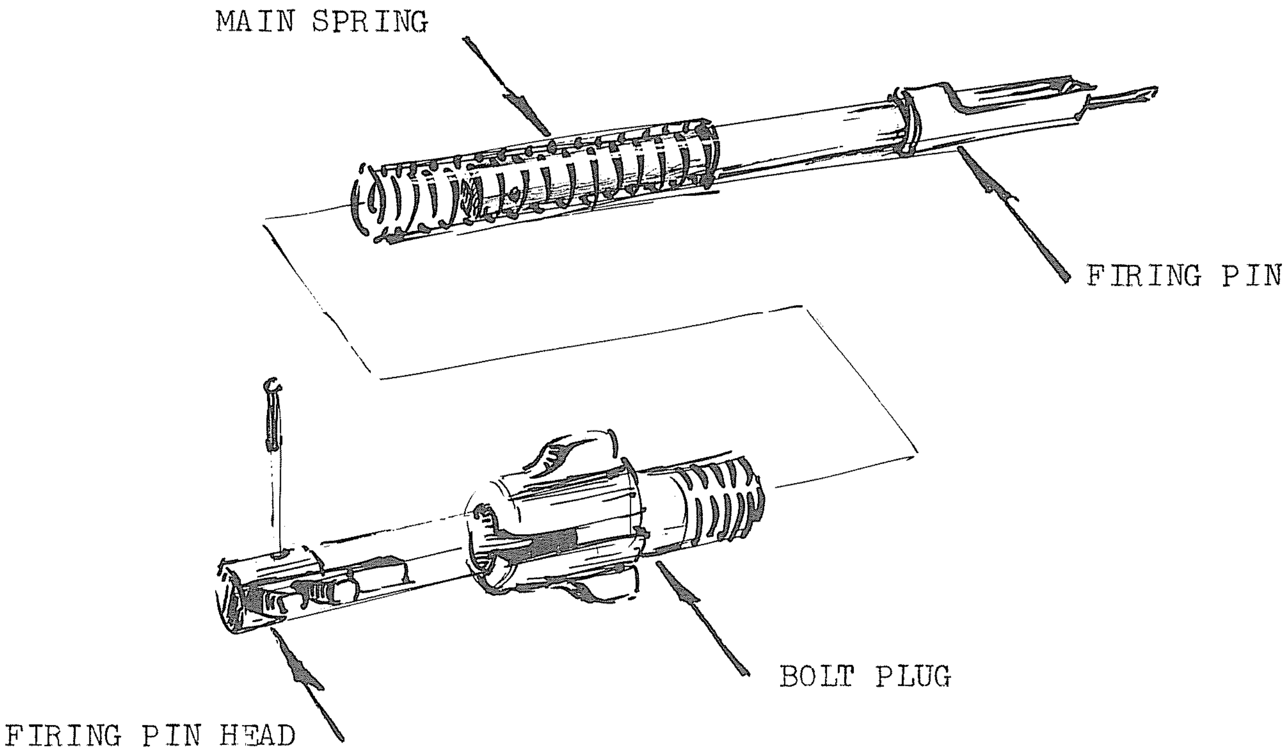
Release pressure on retracted main spring.

Bolt Plug - is designed to screw up and hold firing pin assembly properly assembled to bolt assembly.

Main Spring - is designed to place the firing pin under tension for firing the round.

Firing Pin - is designed to indent the primer and fire the chambered round.

All of the above listed components of the firing pin assembly will be freed as the firing pin head is disassembled, and can be separated. See sketch below.



2. BOLT ASSEMBLY - COMPONENTS: (Continued)
(With bolt assembly removed from rifle)

Firing Pin - (Continued)

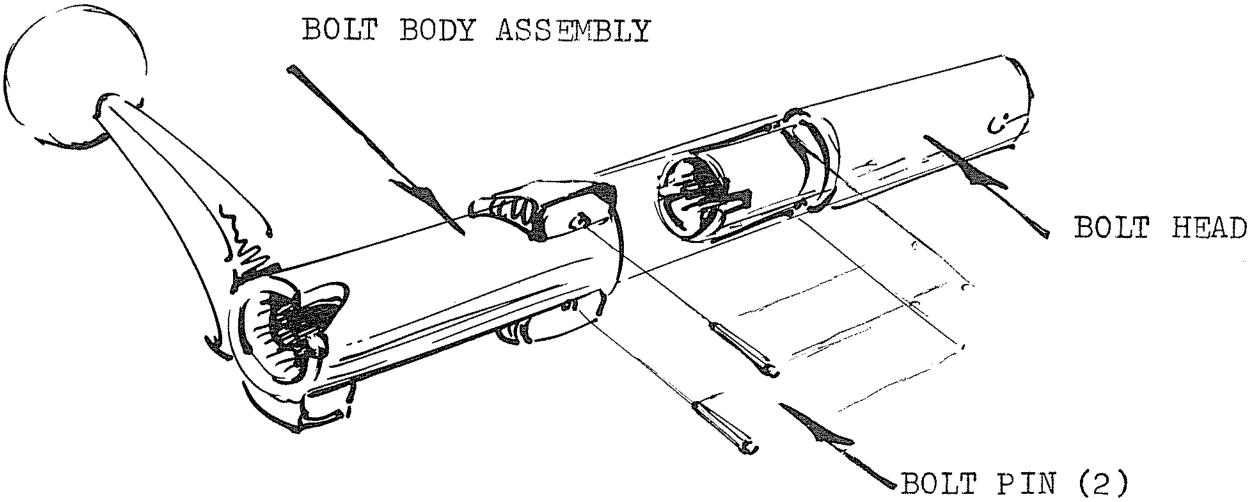
Reassemble in reverse order - with the firing pin head holding all components assembled as a firing pin assembly.

IMPORTANT: A replacement firing pin must be free fitting within the bolt assembly and correct protrusion limits (Maximum .036" - Minimum .031") maintained to produce the proper indent on the round. The firing pin is factory listed to include three (3) components; firing pin point, firing pin body and firing pin shank. All three components are copper brazed under rigidly controlled factory processes for proper assembly. Factory replacement as a unit is recommended.

Bolt Body Assembly - is designed as the middle section of the bolt assembly to provide the opposed locking lugs, and handle to operate the bolt action.

(With firing pin assembly removed)
Drive bolt pin (2) from locking lugs (2) on bolt body assembly.

Pull away and disassemble bolt body assembly from bolt head. See sketch below.



The bolt body assembly includes the bolt body and bolt handle. The components are riveted and copper brazed under rigidly controlled factory processes to form the assembly. Replacement as an assembly is recommended.

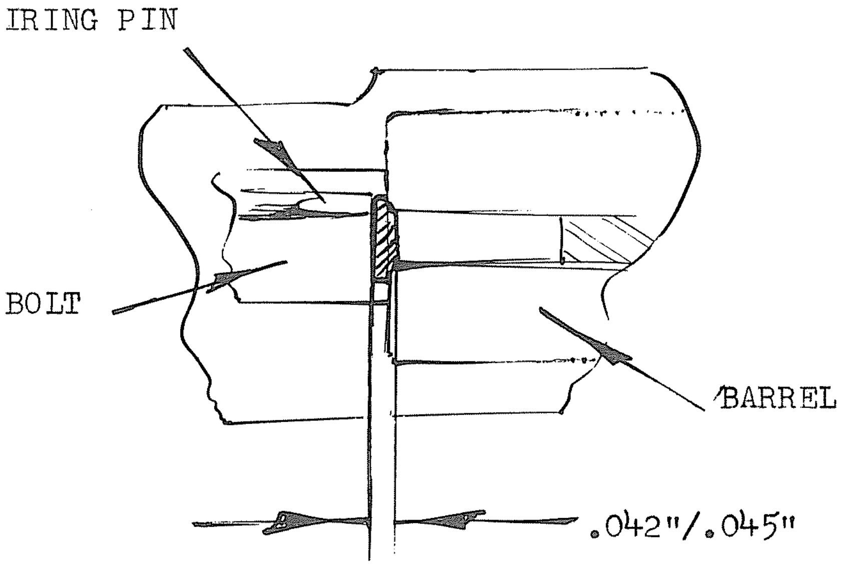
Reassemble in reverse order.

2. BOLT ASSEMBLY - COMPONENTS: (Continued)
(With bolt assembly removed from rifle)

Bolt Head - is designed as the front section of the bolt assembly to breech up the chambered round to the barrel and contain the opposing extractors which grip the rim and guide the extracting and ejecting round.

Bolt Head - will be free and can be disassembled from the bolt assembly when the bolt body assembly is disassembled (See BOLT BODY ASSEMBLY).

IMPORTANT: Replacement of the bolt head requires careful breeching to meet proper headspace limitations between the face of the closed and locked bolt and the chamber rim (.042" to .045"). See sketch below.



Protrusion of the firing pin to established limits, (.031" to .036") for proper indent on the primer of the chambered round, must also be checked when a bolt head is replaced (See Firing Pin).

Reassemble bolt head to bolt body assembly in reverse order.

Extractors, Right and Left - are designed to extract and assist in the ejection of the fired or unfired round.

Force extractor plunger rearward in bolt head and away from rear shoulder of extractor.

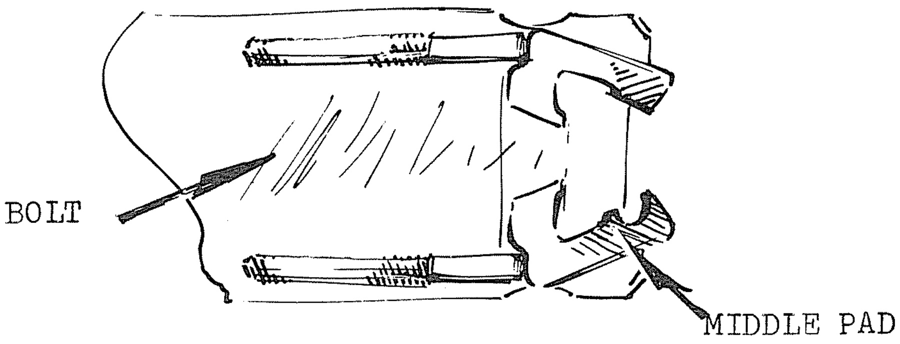
Pry up and raise rear of extractor from slot in bolt head.

Pivot extractor in slot and disassemble from bolt head.

2. BOLT ASSEMBLY - COMPONENTS: (Continued)
(With bolt assembly removed from rifle)

Extractors, Right and Left - (Continued)

NOTE: The shape of the extractor, right, is more claw like than the extractor, left. The extractor, left, is shaped to maintain tension against the opposing grip of this clawlike extractor, right.



Reassemble extractors in order. Replacement extractor may require a tightening adjustment for proper tension against the round. Carefully remove steel from the middle pad of right extractor. See sketch above.

3. BARREL ASSEMBLY:
((With trigger assembly attached)

This basic model assembly is factory listed to include only the barrel, barrel bracket and receiver.

Trigger Guard - is designed as the name implies, to serve as a guard for the trigger and is not a component of the barrel assembly.

Unscrew all three (3) guard screws; rear, middle and front. Disassemble from stock.

Lift loosened trigger guard and disassemble from stock.

Disassemble loosened barrel assembly from stock assembly. NOTE: The trigger guide plate underlies the trigger guard in the stock and can be lifted freely from position after the trigger guard is removed.

3. BARREL ASSEMBLY: (Continued)

Trigger Guard (Continued)

Reassemble in reverse order. NOTE: Settle barrel bracket well back against recoil slot in stock and tighten front guard screw first. Replacement barrel assembly may require rebedding to "float" free of wood contact.

4. BARREL ASSEMBLY - ACTION GROUP:
(With bolt and stock assemblies removed)

Ejector - is designed to trip the extracting round from the grip of the extractors and eject the round from the port. The ejector also serves as a loading platform.

Unscrew ejector screw and disassemble from under surface of receiver.

Lift and disassemble ejector from receiver.

Reassemble in reverse order. NOTE: Position bolt "closed" in receiver when reassembling ejector.

Receiver Filler Piece - is designed to assist in the proper loading of the round.

(With ejector removed)
Tip receiver filler piece from rear and disassemble from receiver.

Dislocate and disassemble receiver filler spring from inner side of receiver filler piece, if desired.

Reassemble in reverse order.

Trigger Assembly - is designed to house the "fire control" components.

Push out sear pin, left to right, to prevent binding against front of bolt stop.

Push out bolt stop pin (longest pin).

NOTE: Sear-safety cam assembly, and sear spring will be loose in trigger assembly when trigger assembly is disassembled from receiver.

4. BARREL ASSEMBLY - ACTION GROUP: (Continued)
(With bolt and stock assemblies removed)

Trigger Assembly - (Continued)

Push out and disassemble trigger assembly from receiver. Replace both pins to hold sear and safety cam assembled to trigger assembly before reassembly, if desired. Replacement assemblies, when received, will be supplied with so called "slave" pins. The bolt stop and sear pins will replace these pins when assembled to receiver.

Bolt Stop and Bolt Stop Spring - are designed to stop the rearward stroke of the bolt after ejection.

(With trigger assembly removed)
Pull out and disassemble bolt stop and bolt stop spring from receiver.

Reassemble in reverse order. Check components for free play in receiver. Stake sear pin and bolt stop pin tightly to receiver.

Barrel - Receiver - is screwed very tightly to the barrel. IMPORTANT: Any replacement of barrel or receiver requires correct head spacing to the barrel and face of closed bolt. Proper alginment of barrel bracket is required.

Unscrew receiver and disassemble from barrel. NOTE: Close fitting holding jaws should be used to prevent damage to barrel or receiver.

Barrel Bracket - is designed as a lug to transfer the recoil of shooting to the stock.

Slip barrel bracket rearward and disassemble from breech of barrel after receiver has been removed.

Reassemble parts in reverse order.

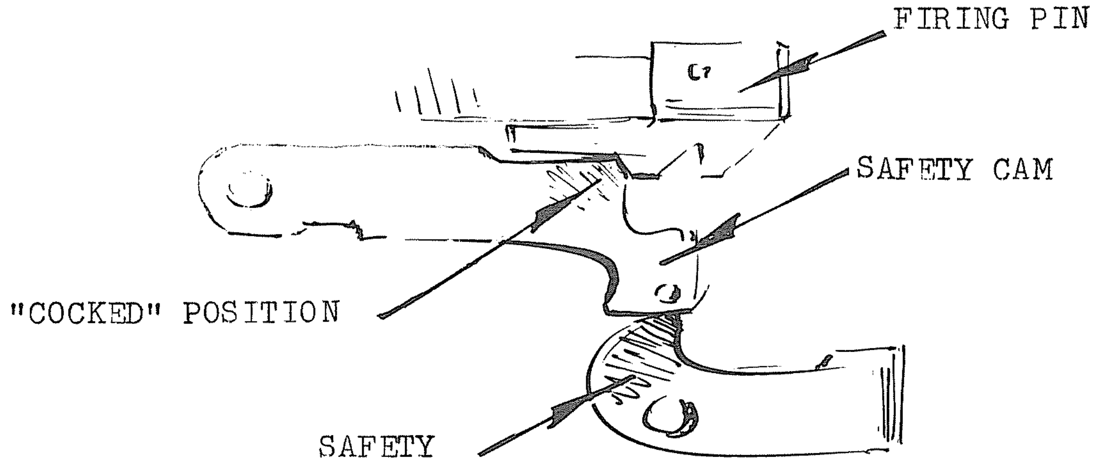
IMPORTANT: The extractor cuts of the assembled and closed bolt must be aligned to the matching cuts in the barrel, when barrel is assembled.

Headspace - limits between the face of the closed bolt and the cartridge rim cut ofthe barrel chamber are listed as .045" max. - .042" min. (See sketch Page 7).

5. TRIGGER ASSEMBLY - COMPONENTS:

The trigger assembly is factory listed to include the bolt stop pin, bolt stop release, connector, safety, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, safety cam-sear assembly, sear pin, sear spring, trigger, trigger adjusting ball, trigger adjusting screw, trigger housing assembly, trigger pin, trigger spring, trigger stop screw, (2).

(With trigger assembly removed from receiver)
Sear and Safety Cam - are designed as a matched unit to hold back the firing pin in "cocked" position and be supported from beneath in this position by the connector. The safety cam section of the unit also holds back the firing pin and is supported from beneath in this position by the safety. (See sketch below). Reassemble in reverse order. (See note bottom Page 9.)



Safety - is designed to support the safety cam from beneath when the safety cam is holding back the firing pin in the "Cocked" position. This rearward support position of the safety to the safety cam represents the "ON SAFE" condition of the rifle.

5. TRIGGER ASSEMBLY - COMPONENTS: (Continued)

Safety - (Continued)

Pry and slide safety snap washer free of safety pivot pin and disassemble from trigger housing assembly.

Lift and disassemble loosened safety detent spring from safety pivot pin and safety.

Lift or shake out safety ball and disassemble from trigger housing assembly.

Push out safety pivot pin and disassemble from trigger housing assembly. (Note flanged head on left side).

Lift out and disassemble loosened safety from trigger housing assembly.

Disassemble bolt stop release from loosened position on trigger.

Reassemble in reverse order.

Trigger Adjusting Screw - is designed to adjust the weight (travel), of trigger pull.

Unscrew and disassemble trigger adjusting screw from trigger housing assembly (bottom).

Shake out and disassemble trigger adjusting ball from trigger housing assembly.

Pull out and disassemble trigger spring from position in trigger adjusting ball hole in front of trigger housing assembly.

Trigger Stop Screw (2) - is designed to adjust the engagement surface of the connector to the sear. (See TRIGGER ADJUSTMENT).

Break seal (Du Pont cement), unscrew and disassemble trigger stop screw from front section of trigger housing assembly. Disassemble trigger stop screw in like manner from rear section of housing.

5. TRIGGER ASSEMBLY - COMPONENTS: (Continued)

Connector - is designed to translate the pulling of the trigger to the release of the sear.

Slide out loosened connector from top of trigger housing assembly.

Trigger - is designed to manually fire the rifle.

Drive out trigger pin and disassemble trigger from trigger housing assembly.

NOTE: The only remaining part of the trigger assembly after all of the above components have been disassembled, is the trigger housing assembly. This remaining assembly part is factory listed to include five (5) components, the trigger side plate (2) and the trigger housing spacer (3). Special factory brazing processes are required in the assembly. Replacement as a unit is required.

Reassemble in reverse order. Replacement parts require adjustment (See TRIGGER ADJUSTMENT below). All components making up the trigger assembly must be reassembled before the trigger assembly is reassembled to the receiver. Bolt assembly must also be reassembled to the rifle before any adjustment can be made.

6. TRIGGER ADJUSTMENT: (Follow directions in order with bolt in rifle - stock removed)

Travel of Trigger - Engagement of under surface of sear to the connector may be observed through hole in trigger housing assembly. (Firing pin will fall or "follow down" if no engagement is made).

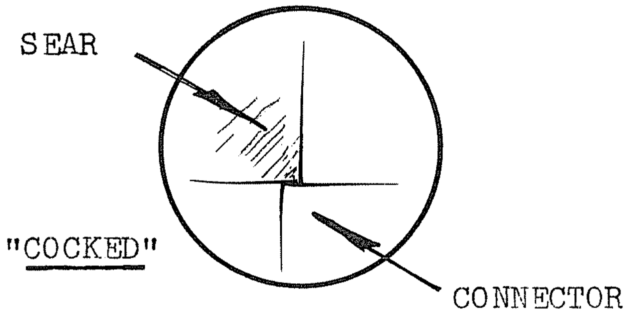
The supporting surface of the connector, engaging the sear may be increased by screwing out the trigger stop screw in rear of trigger housing assembly.

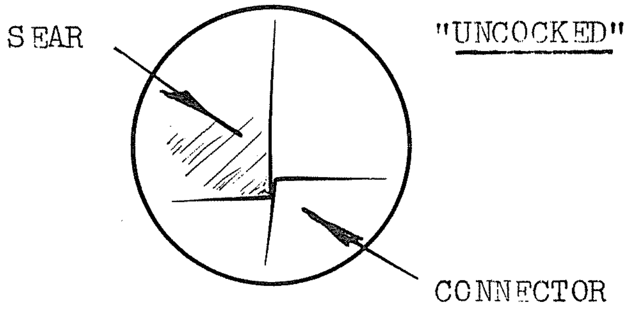
The supporting surface of the connector, engaging the sear may be decreased by screwing in the trigger stop screw in rear of trigger housing assembly.

6. TRIGGER ADJUSTMENT: (Follow directions in order) (Continued)

Travel of Trigger - (Continued)

A simple way - screw in trigger stop screw at rear of trigger housing assembly until firing pin will fall without trigger being pulled. Then screw back trigger stop screw approximately 1/8 turn or until firing pin will not fall unless trigger is pulled. Visual engagement of sear to connector should show approximately .010" (no creep). (See enlarged sketch below).





Overtravel of Trigger - sometimes called overdraw of trigger after rifle has fired, may be lessened by screwing in the trigger stop screw at front of trigger housing assembly.

A simple way - screw in trigger stop screw in front of trigger housing assembly until firing pin will not fall while pulling trigger. Continue pulling trigger and screw out trigger stop screw until firing pin will fall. Then screw out trigger stop screw a fraction more. No perceptible overtravel should be felt.

Reseal both trigger stop screws. Proper staking of rear screw or cement seal or both, necessary to insure no change or "working out" of adjustment.

Weight of Pull - may be increased by screwing in the trigger adjusting screw.

- may be decreased by screwing out trigger adjusting screw.

NOTE: Trigger adjusting screw is located at bottom of trigger housing assembly and can be adjusted with rifle completely assembled. The weight of pull is adjusted at the factory for 3 to 3½ pounds.

7. STOCK - STOCK ASSEMBLY:

The stock is designed as a wood member to carry and hold the barrel and action when firing.

Unscrew and disassemble all three guard screws, rear, middle and front.

Disassemble loosened trigger guard from stock.

Remove stock from barrel and action.

Remove trigger guide plate which underlays the trigger guard.

The stock is factory listed to include the stock, butt pad and butt pad screw (2). Also supplied, is an alternate replacement unit, the "STOCK ASSEMBLY." This unit is factory listed to include the stock, butt pad, butt pad screw (2), bedding escutcheon assembly (2), front swivel assembly and front swivel base screw (2). NOTE: The stock alone without butt pad or screws is not supplied.

Reassemble stock in reverse order. Barrel should "float" in stock and have approximately .010" clearance from wood. When replacing stock, specify standard or heavy barrel type.

8. STOCK ASSEMBLY - COMPONENTS:
(With stock removed from rifle)

Butt Pad - Unscrew butt pad by reaching into open hole (2) in rear of pad.

Disassemble butt pad from stock.

Reassemble in reverse order. Replacement of butt pads should show tight fit and slight rubber rather than wood margin.

Front Swivel Assembly - is designed to adjust and hold the position of the shooting sling.

Unscrew front swivel screw and disassemble front swivel, front swivel bushing, front swivel block, front swivel washer from front swivel base in stock.

Reassemble to front swivel assembly in reverse order.

8. STOCK ASSEMBLY - COMPONENTS: (Continued)
(With stock removed from rifle)

Front Swivel Base - is designed to position the front swivel in desired location.

Unscrew front swivel base screw (2) and disassemble base and front swivel nut from stock. Use care to prevent wood split as nut is tightly fitted. Reassemble in reverse order.

Bedding Escutcheon Assembly - is designed to contact barrel, if desired, and control vibration when shooting.

Tap out or drive toward the barrel groove in the stock, and disassemble the bedding escutcheon assembly (2) from the stock.

Reassemble in reverse manner making sure that large diameter of the assembly seats below the wood surface in the barrel groove.

9. BEDDING ESCUTCHEON ASSEMBLY - COMPONENTS:

This assembly is factory listed to include the bedding escutcheon, bedding screw, bedding detent ball, bedding detent spring.

(With assembly removed from stock)
Unscrew bedding screw from bedding escutcheon part way until. . .

Bedding ball can be disassembled from a spring tensed position against the knurl of the bedding screw. Use care to prevent losing bedding ball when bedding screw is backed out of bedding escutcheon.

Bedding screw - can then be unscrewed completely from the bedding escutcheon and disassembled from the escutcheon.

Bedding detent spring - can be picked from recess in thread of bedding escutcheon after bedding screw and bedding detent ball have been disassembled.

Reassemble in reverse order. When reassembling bedding detent ball, hold ball down against spring until bedding screw will cover same. Use small drill or rod against ball from small hole opposite, in large diameter of escutcheon. Bedding screw should be returned flush or below surface of large diameter on bedding escutcheon.

10. SIGHTS:

Standard Barrel S2 - is furnished without sights. However, sighting equipment on the S2 includes telescope base, front; telescope base, rear; telescope base screw (4). Receiver plug screw (6) are also included, two are screwed into position near the muzzle of the barrel; four are screwed to the receiver, two on left rear of receiver and two on top front of receiver.

Heavy Barrel H2 - is also furnished without sights. Sighting equipment on the H2 includes same as S2 except a shorter height telescope base, front, is used to keep the same receiver alignment. This, of course, means a shorter telescope base screw is used.

Standard Barrel S1 - is furnished with Redfield Olympic sights; Redfield front sight No. 1 with ten (10) inserts or sighting apertures, and Redfield receiver sight. Both Redfield sights have their own bases that replace the receiver plug screws, at muzzle and rear left side of receiver. Both sights may be disassembled from their respective base. For "shipment", new guns from the factory are packaged with the Redfield sights dismounted from their base on the rifle.

Heavy Barrel H1 - is also furnished with Redfield Olympic sights identical with the type on the S1 except for the variation in height to keep the same sight line at the receiver.

Telescope Bases - are furnished on all model types, standard or heavy barrel, and with or without Redfield sights.

The rear telescope base is assembled to the rear position on the receiver when the rifle is shipped. This rear position arrangement for "wide base" location of the telescope, requires six (6) adjusting clicks of the telescope to change the center of impact one inch on the 100 yard target.

With the rear telescope base moved to the front, "close base" position on the receiver, four (4) adjusting clicks are required to change the center of impact one inch on the 100 yard target.

Malfunctions occuring in the Model 40X are listed mainly in relation to the action of the bolt assembly. Listed below is an index of probable malfunctions and a suggested method of correction.

1. BOLT FAILS TO ASSEMBLE.
2. BOLT CLOSES HARD.
3. BOLT FOLLOWS DOWN (Uncocks).
4. BOLT MISFIRES.
5. BOLT FAILS TO EXTRACT.
6. BOLT OPENS HARD.
7. BOLT FAILS TO EJECT.
8. BOLT PULLS OUT.
9. SAFETY FAILS.
10. TARGET - GROUP FAULT.
11. TARGET - CENTER OF IMPACT FAULT.

Instruction Folders, supplied with each new gun, advise as to proper maintenance and care of the rifle. Additional copies are available from the factory upon request.

1. BOLT FAILS TO ASSEMBLE

Cause:

a. Bolt uncocked.

b. Bolt stop damaged.

c. Bolt head rotated slightly out of position.

d. Receiver filler piece binds bolt.

Correction:

a. Cock bolt. See BOLT ASSEMBLY.

b. Replace or adjust. Check bolt stop release.

c. Re-position bolt head radially.

d. Depress receiver filler piece into receiver.

2. BOLT CLOSES HARD

Cause:

a. Rough chamber.

b. Rough cam in receiver.

c. Bolt lugs damaged.

d. Too little headspace. (.042" Min., .045" Max.)

e. Extractor cut in barrel damaged.

Correction:

a. Repolish (lightly) or replace barrel.

b. Smooth up cam or replace receiver.

c. Smooth up bolt lugs or replace bolt body assembly.

d. Adjust headspace or replace barrel.

e. Clear up damage or replace barrel.

3. BOLT FOLLOWS DOWN (Uncocks)

Cause:

a. Engagement of sear to connector lacking or insufficient to hold.

3. BOLT FOLLOWS DOWN (Uncocks) (Continued)

Cause: (Continued)

- b. Trigger fails to retract.
- c. Sear damaged.
- d. Connector damaged.
- e. Sear and connector sticky.

Correction: (See ASSEMBLY - TRIGGER ADJUSTMENT)

- a. Adjust engagement in trigger assembly.
- b. Adjust in trigger assembly or replace.
- c. Replace sear and safety cam assembly (matched set).
- d. Replace connector.
- e. Clean components.

4. BOLT MISFIRES

Cause:

- a. Firing pin short, damaged.
- b. Firing pin binds in bolt assembly - light firing pin blow.
- c. Trigger assembly faulty.
- d. Main spring damaged.
- e. Ammunition faulty.

Correction:

- a. Replace firing pin - check protrusion carefully.
- b. Free up travel of firing pin or replace. Clean components.
- c. Adjust trigger assembly (See ASSEMBLY - TRIGGER ADJUSTMENT).
- d. Replace main spring.
- e. Discard ammunition.

5. BOLT FAILS TO EXTRACT

NOTE: Make certain safety is in forward or "FIRE" position. Bolt handle will lock down in rear or "ON SAFE" position.

Cause:

a. Extractor (right) damaged or missing.

b. Extractor (right) grip on cartridge faulty.

c. Extractor slots in barrel damaged, shallow.

d. Rough or damaged chamber.

e. Fired cartridge bulged at base.

Correction:

a. Replace extractor, right.

b. Adjust hook space on cartridge. Remove some metal from middle pad on extractor. Check extractor plunger and spring.

c. Repair extractor slots or replace barrel.

d. Repolish chamber - use caution. Do not exceed chamber dimensions.

e. Check headspace or replace barrel.

6. BOLT OPENS HARD

Cause:

a. Extraction faulty.

b. Extraction cam on base of bolt handle damaged.

c. Filler piece damaged, defective.

d. Trigger guard screws protrude into bolt track.

e. Telescope base screws protrude into bolt track.

f. Wood interferes with bolt handle.

6. BOLT OPENS HARD (Continued)

Correction:

a. See FAILS TO EXTRACT.

b. Repair or replace bolt body assembly.

c. Adjust or replace filler piece.

d. Shorten length of guard screws.

e. Shorten length of telescope base screws.

f. Provide proper clearance for bolt handle.

7. BOLT FAILS TO EJECT

Cause:

a. Ejector (loading platform) damaged, loose.

b. Cartridge loose under extractors.

c. Extraction faulty.

Correction:

a. Replace or tighten ejector.

b. Adjust grip of extractors to cartridge. Check retraction of firing pin.

c. See FAILS TO EXTRACT.

8. BOLT PULLS OUT

Cause:

a. Bolt stop damaged.

b. Bolt stop release damaged.

c. Bolt stop binds down.

Correction:

a. Adjust or replace bolt stop.

b. Adjust or replace bolt stop release.

c. Replace bolt stop spring. Remove burrs, if any. Clean components.

9. SAFETY FAILS

Cause:

a. Safety binds.

b. Safety loose.

c. Safety damaged.

Correction:

a. Remove stock, adjust operation of safety.

b. Remove stock, check safety snap washer.

c. Remove stock, replace safety.

10. TARGET - GROUP FAULT

Cause:

a. Cartridge chamber worn long, defective.

b. Firing pin indent faulty.

c. Barrel bore or muzzle damaged.

d. Barrel bedding faulty.

e. Sights defective, loose.

Correction:

a. Replace barrel (check headspace to bolt).

b. Adjust or replace firing pin.

c. Lead or replace barrel. Check for muzzle damage.

d. Adjust bedding of barrel to stock. Tighten front and rear trigger guard screws.

e. Adjust or replace sights.

11. TARGET - CENTER OF IMPACT FAULT

Cause:

a. Barrel crooked.

b. Barrel bore or muzzle damaged.

c. Sights faulty.

Correction:

a. Replace or straighten barrel. IMPORTANT: (Check headspace to bolt, if replacing).

b. Replace barrel, lead bore, repair or recrown muzzle.

c. Adjust or replace sights.

SECTIONAL VIEW